

Work Order ID 126841

November-27-14 7:11:24 AM

~~Slip Des~~ *126841*

Page 1

Item ID: D2563

Revision ID:

Item Name: Step Weldment Assembly

Start Date: 11/27/14 Start Qty: 4.00

Required Date: 12/04/14 Req'd Qty: 4.00

Reference:

Approvals:

Process Plan: U

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run

Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2563

Rev C

100

0.00

100

Large Fab

Large Fab

Large Fab

Memo

0.00

1-Cut D2244 to 89.70" at 34 deg as per dwg D2563

2-Debur ends

3-Weld (1 END CAP, LUG PLATES & MOUNTING ANGLE) as per dwg D2563 using DT 8343

4- Grind

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Quality Control

Memo

0.00

DAS
24
9-89

JAN 14 2015

4X

02/14/12/01

~~JAN 14 2015~~ ~~DAS 24 9-89~~

④ 15-01-17

PD

Work Order ID 126841

126841

Page 2

November-27-14 7:11:24 AM

Item ID: D2563 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Weldment Assembly
 Start Date: 11/27/14 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 12/04/14 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00				4/	0		
120									
QC	Memo	0.00							
Quality Control									
130	Chemical Conversion Coat per QSI005 4.1	0.00				4X			
130									
HandFinish	Memo	0.00							
Hand Finishing									
140	QC7-Inspect Chemical Conversion Coat	0.00				(4)			
140									
QC	Memo	0.00							
Quality Control									

15/01/14 49 9-89
 DAS 9-89

0215/1/26

49 9-89
 DAS 9-89
 15-01-28

Work Order ID 126841***126841***

Page 3

November-27-14 7:11:24 AM

Item ID: D2563 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Step Weldment Assembly
Start Date: 11/27/14 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 12/04/14 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Large Fab Large Fab	Weld per dwg A/R Aluminum rod Batch: <u>3130855</u> Large Fab Memo 1-Inspect for foreign object per QSI 024 2-Weld Remainig End cap as per Dwg D2563 using DT 8343 3-Grind	0.00 0.00						<u>4</u> <u>CC15-1-28</u>	
160 *160* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00						<u>4</u> <u>JAN 28 2015</u>	DAS 24 9-89
170 *170* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00						<u>4</u> <u>JAN 28 2015</u>	DAS 24 9-89

Work Order ID 126841

126841

Page 4

November-27-14 7:11:24 AM

Item ID: D2563 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Weldment Assembly
 Start Date: 11/27/14 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 12/04/14 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
175	Pressure Wash per QSI005 4.3	0.00							
175									
HandFinish	Memo	0.00							
Hand Finishing	Touch up Alodine as per QSI005								
180	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
180									
Powdercoat	Memo	0.00							
Powder Coating	Touch up Alodine then Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3								
	START TIME: <u>3:40</u>								
	OVEN TEMPERATURE: <u>320</u>								
	FINISH TIME: <u>4:10</u>								
190	Wing Walk as per dwg QSI005 4.4 Batch _____	0.00							
190									
HandFinish	Memo	0.00							
Hand Finishing									

4X DK 15/1/98

H φ 15-1-28. DAS 34 9.88

4c f Ill 15/01/29

Work Order ID 126841

126841

Page 5

November-27-14 7:11:24 AM

Item ID: D2563 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Weldment Assembly
 Start Date: 11/27/14 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 12/04/14 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	QC3- Inspect Part Finish	0.00				(4)			DAS 38 9-89
200									
QC	Memo	0.00							
Quality Control									

JAN 29 2015

210	Identify as per dwg & Stock Location	0.00							
210									
Packaging	Memo	0.00							
Packaging									

DAS
06
9-89

JAN 30 2015

220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.00							
Quality Control									

MCS

1501-30

W 1501-30

Picklist Print

November-27-14 7:11:24 AM

Page 1

Work Order ID: 126841

126841

Parent Item: D2563

D2563

Parent Item Name: Step Weldment Assembly

Start Date: 11/27/14

Required Date: 12/04/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:G 02.07.31 Re-format Location RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2244-116		Manufactured	No			100	Each	188.0000	1	4			
D2244-116									**				
STEP EXTRUSION													

OK 14/12/01

Location	Loc Qty	Loc Code
HALL	138	
117818	138	
WA003	49.9999632	
104940	41	
60307	9	

D2561

Manufactured No

100 Each 27.0000 2 8

D2561

Lug

Location	Loc Qty	Loc Code
WA003	27	
114805	7	
124408	20	

Plc 14-12-10
B124408 → 8

D2564

Manufactured No

100 Each 25.0000 2 8

D2564

Mounting Angle

Location	Loc Qty	Loc Code
WA003	25	
117175	5	
123106	20	

Plc 14-12-10
B117175 → 5
B123106 → 3

Picklist Print

November-27-14 7:11:24 AM

Page 2

Work Order ID: 126841

126841

Parent Item: D2563

D2563

Parent Item Name: Step Weldment Assembly

Start Date: 11/27/14

Required Date: 12/04/14

Start Qty: 4.00

Required Qty: 4.00

D2673-34

Manufactured No

100

Each

17.0000

1

4

DAS
24
9-89

JAN 14 2015

D2673-34

End Plate

Location

Loc Qty

Loc Code

WA003

17

113204

13

117775

4

B127168 → 4

D2673-34

Manufactured No

150

Each

17.0000

1

4

CC 15-1-28

D2673-34

End Plate

Location

Loc Qty

Loc Code

WA003

17

113204

13

117775

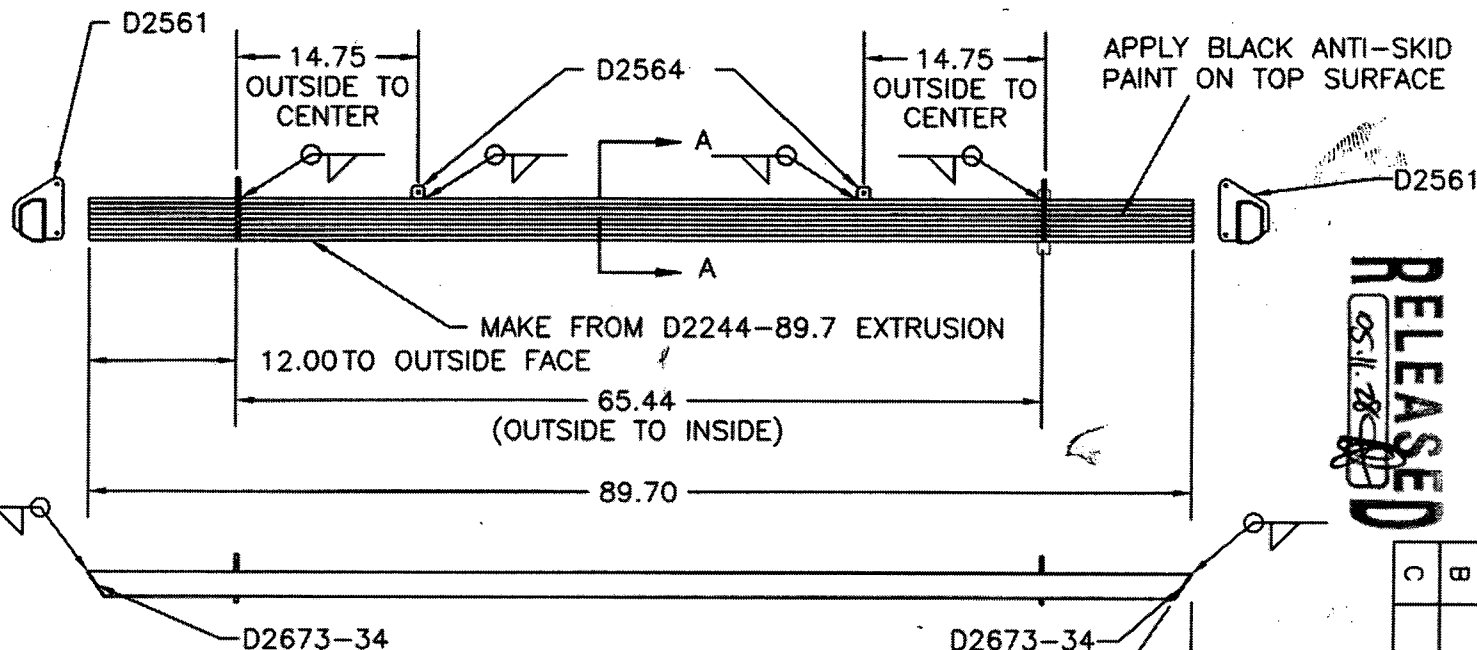
4

B127168

④



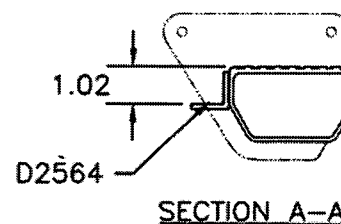
RELEASED
05.11.28



D2563 STEP WELDMENT ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

*cut per drawing



SECTION A-A

D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	BW	DRAWN BY	DART AEROSPACE LTD
CHECKED		APPROVED	DART AEROSPACE LTD
DATE	05.11.14	DRAWING NO.	D2563
TITLE	STEP WELDMENT ASSEMBLY	REV. C	
SCALE	1:15	SHEET 1 OF 1	
REV. C			
DATE	05.11.14		
DESCRIPTION	END CAPS CHANGED (WAS D2248)		
REVISION	UPDATE NOTES		